

**AMENDMENTS TO THE SPECIFICATION**

**Please amend as shown the following two paragraphs that start on page 1, line 9.**

This application is a continuation-in-part of commonly-owned, copending U.S. Patent Application Serial No. 09/960,215 entitled **EXPANDABLE TIRE BUILDING DRUM WITH ALTERNATING FIXED AND EXPANDABLE SEGMENTS, AND CONTOURS FOR SIDEWALL INSERTS**, Attorney's Docket No. DN2001168USA, and filed on even date herewith September 21, 2001.

This application relates to U.S. Patent Application Serial No. 09/957,785 entitled **METHOD FOR MANUFACTURING TIRES ON A FLEXIBLE MANUFACTURING SYSTEM**, Attorney's Docket No. DN2001166USA and filed on even date herewith September 21, 2001.

**Please amend as shown the following paragraph that starts on page 30, line 21.**

Figure 7 also illustrates turnup bladders disposed on the end sections 722, 724. A bottom turnup bladder 712a is disposed on the outer surface of the end section 722. A bottom turnup bladder 712b is disposed on the outer surface of the end section 724. A top turnup bladder 714a is disposed over the bottom turnup bladder 712a on the outer surface of the end section 722. A top turnup bladder 714b is disposed over the bottom turnup bladder 712b on the outer surface of the end section 724. As is generally well known, the turnup bladders 712a/b and 714a/b arc for turning up turnup ends of the green carcass around respective beads 734a and ~~734b~~ 716a and 716b (compare 134a and 134b; also 512-~~514~~).

**Please amend as shown the following paragraph that starts on page 32, line 19.**

As shown in Figure 7, pneumatic line 744 directs pressurized air through air passageway PW1 behind piston P1. Pneumatic line 742 directs pressurized air through air passageway PW2 between pistons P1 and P2. ~~Although not~~ As shown in Figure 7A, pneumatic line 742-745 directs pressurized air through ~~an unseen~~ air passageway ~~at~~ PW3 between piston P2 and annular projection 736.

**Please amend as shown the following paragraph that starts on page 33, line 29.**

Three pneumatic lines 742, ~~743 and 744~~ and 745 are provided, along with associated passageways PW1, PW2 and PW3 in the cylinder block (730) for providing pressurized air at the following locations:

**Please amend as shown the following paragraph that starts on page 35, line 7.**

Retraction of the bead lock assembly 726 is accomplished by providing pressurized air though the line ~~743-745~~ into the passageway PW3 (see Figure 7A) to the axially inward side of the piston P2. At the same time the pressurized air in lines 742 and 744 is stopped. The pressurized air in line ~~743-745~~ causes the piston P2 to move axially outward, thereby via the rods R1P2, R2P2, R3P2 moving the carrier ring CR axially outward, thereby via the links K moving the expandable segments S and finger segments F radially inward, thereby decreasing the diameter of the bead lock assembly 726 to its fully-collapsed condition. The piston P2 moves axially outward until it is stopped by the piston P1. If, in the previous step, the piston P1 had been restrained from retracting, in its intermediate position, it could be selectively maintained in the unretracted position, and the axially outward movement of the piston P2 would be limited by the piston P1, thereby establishing a partially-collapsed condition for the bead lock assembly, after which by allowing the piston P1 to retract fully, the piston P2 could move further axially outward to allow the bead lock assembly to achieve its fully-collapsed condition.

**Please amend as shown the following paragraph that starts on page 35, line 31.**

To summarize the expansion/contraction of the bead lock assembly 726, ~~[[p]]~~pressurized air supplied through the first passage 744 via the first passageway PW1 to an outer side of the first piston P1 causes the first piston P1 to move axially inward, pushing the second piston P2 also axially inward, until constrained by the rods R1P1, R2P1, R3P1, so that the bead lock assembly 726 is partially-expanded. Pressurized air supplied through the second passage 742 via the second passageway PW2 to a location between the inner side of the first piston P1 and the outer side of the

second piston P2 causes the second piston P2 to move further axially inward, until stopped by a projection 736, so that the bead lock assembly 726 is fully-expanded. Pressurized air supplied through the third passage ~~743-745~~ via the third passageway PW3 to a location on the inner side of the second piston P2 causes the second piston P2 to move axially outward, so that the bead lock assembly 726 is fully collapsed unless stopped by the first piston P1 as discussed above.